

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005396**Date Inspected:** 04-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Fabrication**Summary of Items Observed:**

CWI: Mr. Sun Wei

On this date CALTRANS OSM Quality Assurance (QA) Inspector Mr. Paul Dawson arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

OBG Bay 9

This QA Inspector observed ZPMC welder Mr. Xing Jie, stencil 59378 is using flux cored welding procedure WPS-345-FCAW-1G(1F)-Repair-1 to make repairs to OBG deck plate DP575-001 weld #17R1. Prior to welding the QA Inspector observed the base material had been preheated using electrical heater elements. The QA Inspector observed a Quality Control Inspector measuring Mr. Jie welding with a current of 290 amps and 30.0 volts. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

This QA Inspector observed ZPMC welder Mr. Han Siqi, stencil 202842 is using flux cored welding procedure WPS-345-FCAW-1G(1F)-Repair-1 to make repairs to OBG deck plate DP585-001 weld #17R1. Prior to welding the QA Inspector observed the base material had been preheated using electrical heater elements. The QA Inspector observed a Quality Control Inspector measuring Mr. Siqi welding with a current of 310 amps and 30.0 volts. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

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This QA Inspector observed ZPMC welder Mr. Yan Ttianbing, stencil 66439 is using flux cored welding procedure WPS-345-FCAW-1G(1F)-Repair-1 to make repairs to OBG deck plate DP585-001 weld #13R1. Prior to welding the QA Inspector observed the base material had been preheated using electrical heater elements. The QA Inspector observed a Quality Control Inspector measuring Mr. Ttianbing welding with a current of 310 amps and 31.5 volts. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
